

# Work Order ID 78148

December-29-11 10:36:30 AM

**\*78148\***

Page 1

Item ID: D2662-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, LH In 206  
 Start Date: 29/12/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 06/02/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/29 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev E								

100  
**\*100\*** HAAS CNC VERTICAL MACHINING #1 0.00  
 HAAS 1 Memo 0.00 10 ✓  
 HAAS CNC vertical machine #1  
 Program part number and batch number.  
 Inspect part number and batch number are programmed SL 12-01-18  
 MACHINE AS PER FOLIO FB068 & DWG  
 DWG REV: E  
 FOLIO REV: AA

110  
**\*110\*** CONVENTIONAL MILLING MACHINE 0.00  
 Mill Conv Memo 0.00 10 ✓  
 Conventional Milling Machine  
 Machine Keyway and inspect per attached dimension sheet SL 12-01-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**\*78148\***

December-29-11 10:36:30 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*10\***

**Cust Item ID:**

**\*10\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00
-----	--	------

**\*150\***

Powdercoat

## Powder Coating

## Memo

START TIME:

OVENTEMPERATURE:

FINISH TIME:

0.00

160

### QC3- Inspect Part Finish

0.00

**\*160\***

QC

## Quality Control

## Memo

0.00

170

Identify as per dwg & Stock Location: ST 429 0.00

**\*170\***

## Packaging

## Packaging

## Memo

0.00

W/O:		WORK ORDER CHANGES					
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**Work Order ID 78148**

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Page 4

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Revision ID: Stop **\*NS2\***  
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Start Date: 29/12/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
Required Date: 06/02/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

12/11/24

12-01-24  
10

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

December-29-11 10:36:33 AM

Page 1

Work Order ID: 78148

**\*78148\***

Parent Item: D2662-1

**\*D2662-1\***

Parent Item Name: Saddle, LH In 206

Start Date: 29/12/2011

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

**Comments:**

IPP: C00.06.22Removed P/O for powder coatEC

IPP Rev:D As per Rev D 07-03-19 JLM

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001

Manufactured

No

100

Each

104.0000

1

10

**\*D6101-001\***

**\*\***

As 12/21/11

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

104

69677

2

→ 73774

50

74679

6

76836

46

10.0

W/O:		WORK ORDER CHANGES					
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<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 78148	
<b>Description:</b> 206 Saddle, Inboard, Left side				<b>Part Number:</b> D2662-1	
<b>Inspection Dwg:</b> D2662 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 2</b>	

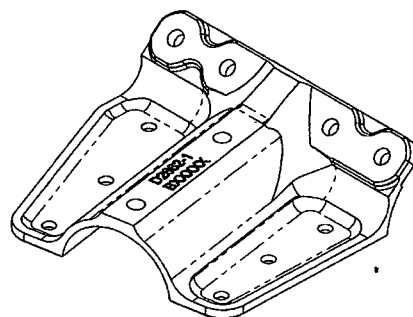
### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.257	.257	.257	.257	.257
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.120	.120	.120	.120	.120
G	0.210	0.230		.219	.220	.219	.219	.219
H	0.615	0.685		.685	.685	.685	.685	.685
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.323	1.323	1.323	1.323	1.323
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.135	1.135	1.135	1.135	1.135
N	0.100	0.180		.140	.140	.140	.140	.140
O	0.100	0.145		.134	.132	.132	.132	.133
P	0.240	0.260		.248	.249	.248	.248	.248
Q	0.677	0.697		.687	.687	.687	.687	.687
R	0.540	0.560		.549	.550	.550	.549	.549
S	0.912	0.932		.922	.921	.921	.922	.921
T	0.787	0.807		.797	.797	.797	.797	.797
U	5.990	6.010		5.999	5.999	5.999	5.999	5.999
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.500	.501	.502	.501	.501
X	0.312	0.319		.313	.313	.313	.313	.313
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.118	.118	.118	.118	.118
AE	0.235	0.240		.237	.237	.237	.237	.237
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.110	.110	.110	.110	.110
<b>Accept/Reject</b>								
<b>Measured by:</b> SL				<b>Date:</b> 12-01-18				
<b>Audited by:</b> CMX				<b>Date:</b> 12/01/19				
<b>Prototype Approval:</b>				<b>Date:</b>				

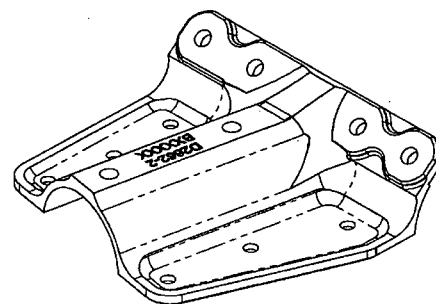
<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 78148	
<b>Description:</b> 206 Saddle, Inboard, Left side				<b>Part Number:</b> D2662-1	
<b>Inspection Dwg:</b> D2662 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 2</b>	

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Z								
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AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.110	.110	.110	.110	.110
Accept/Reject								
<b>Measured by:</b> J				<b>Date:</b> 12-01-18				
<b>Audited by:</b> [Signature]				<b>Date:</b> 12/01/19				
<b>Prototype Approval:</b>				<b>Date:</b>				



**D2662-1 SADDLE, INSIDE, LH**



**D2662-2 SADDLE, INSIDE, RH**

STRAIGHTLY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 78148

**RELEASED**  
2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4); REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP' DEO 0122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE USA, INC.		
DRAWN	KENT, WA		
CHECKED	A.S.	DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
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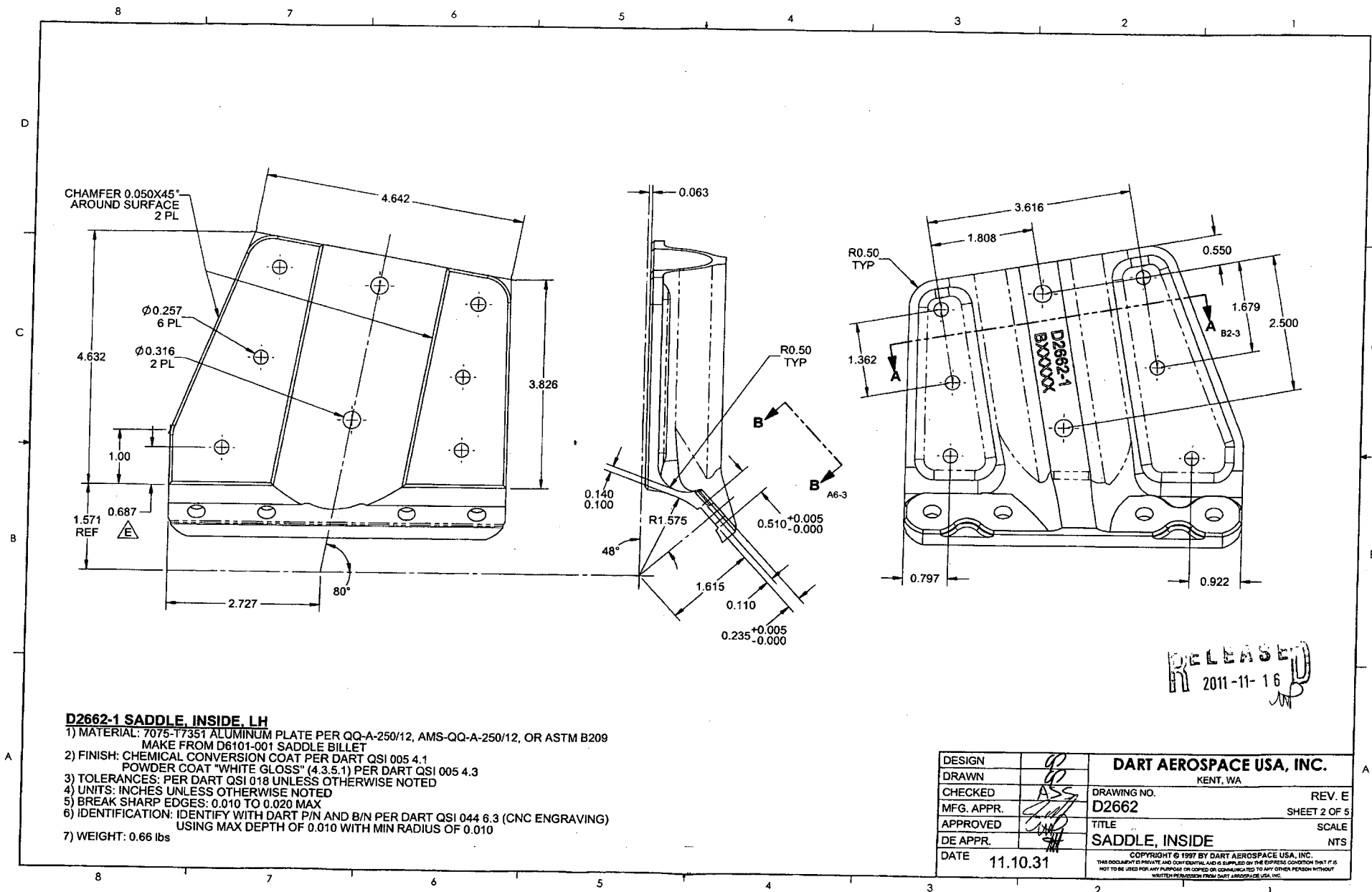
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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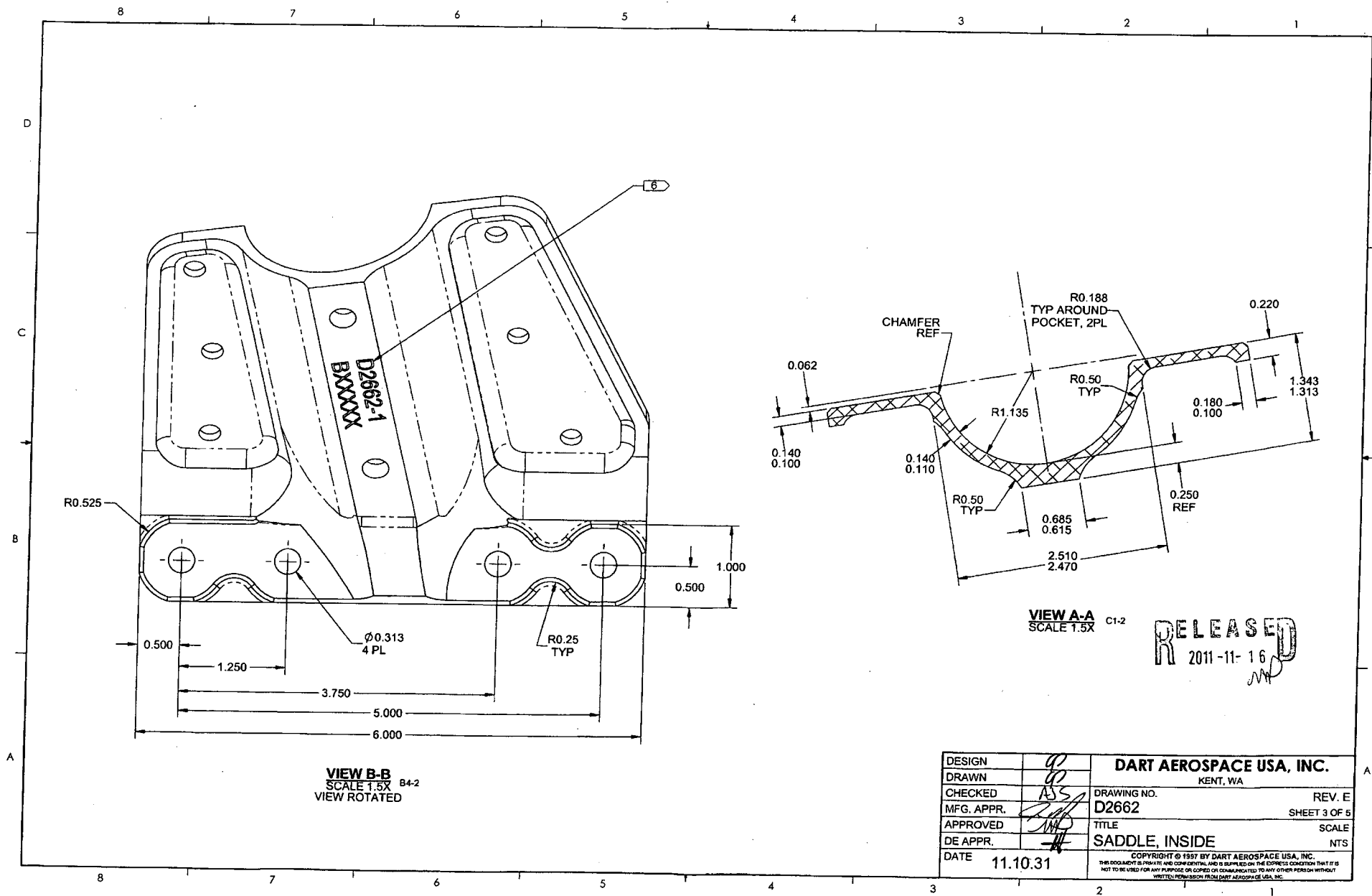
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78148



RELEASED  
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	GP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
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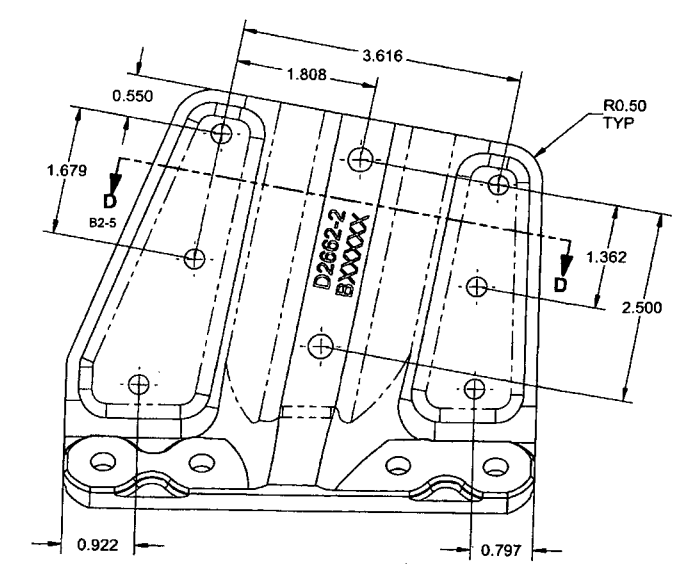
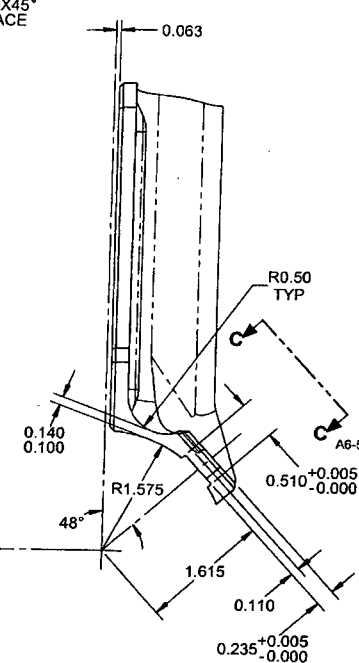
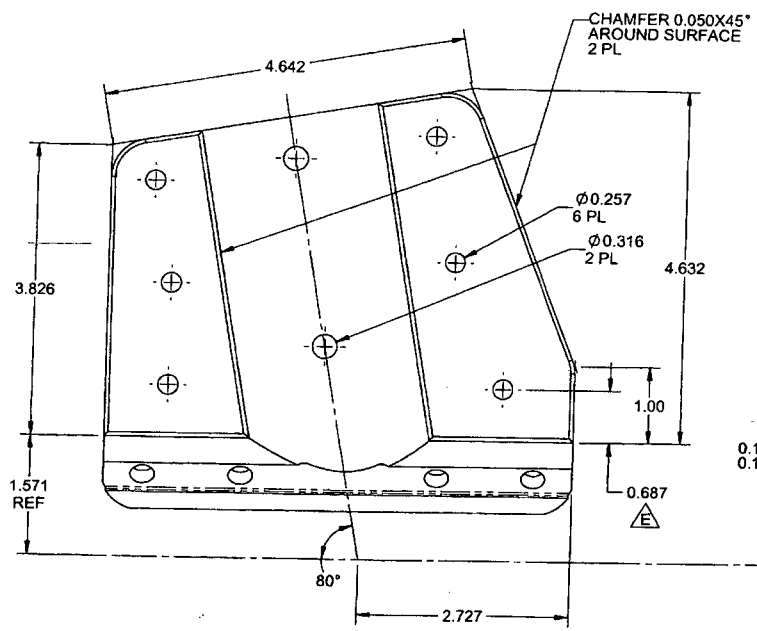
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RELEASED  
2011-11-16

# D2662-2 SADDLE, INSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209 MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
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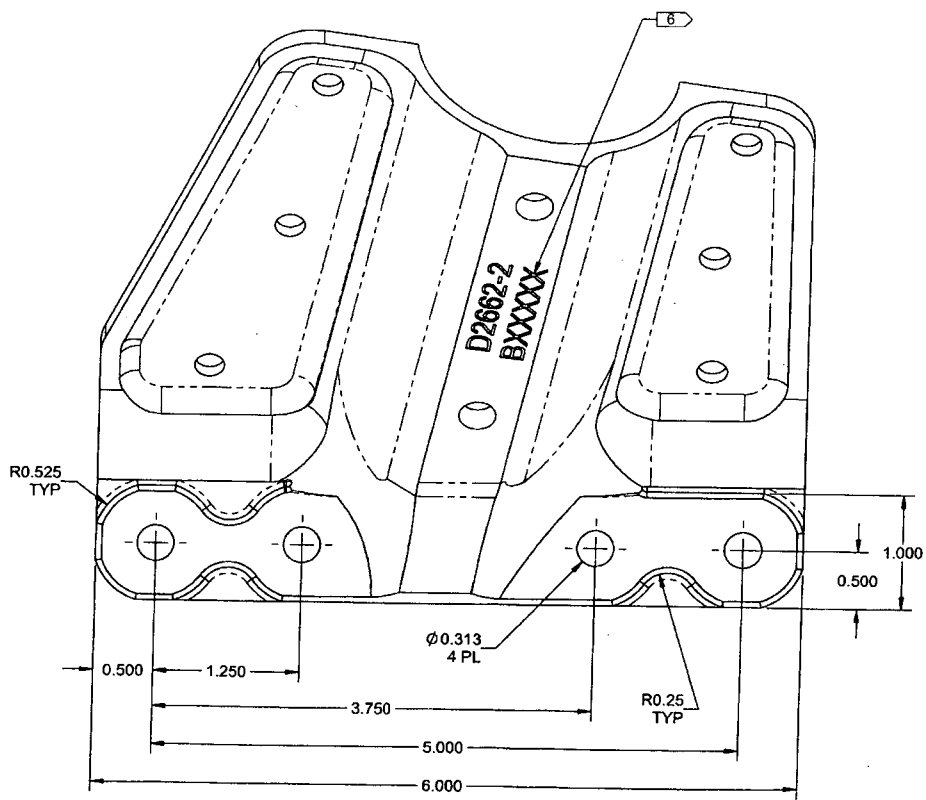
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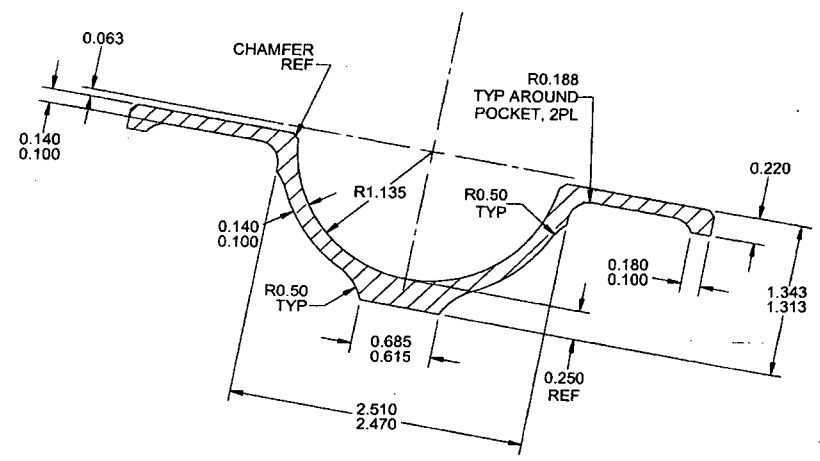
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VIEW D-D  
SCALE 1.5X  
VIEW ROTATED



VIEW C-C  
SCALE 1.5X C3-4

RELEASED  
2011-11-16

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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 5 OF 5
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DE APPR.		SADDLE, INSIDE	NTS
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries